

Date: Monday, 02/03/2009 11:23:58 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL
<b>Job Number</b> : 46174	
<b>Estimate Number</b> : 10873	
<b>P.O. Number</b> :	<b>Part Number</b> : D32455
<b>This Issue</b> : 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3245 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 43768	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JULIA 09.03.02</u>	
<b>Comment</b> : Est. A 04.07.07 New issue KJ/JLM	
Est Rev:b ECN 1052 07-10-31 DD verified by:	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S22GA

304/316 .032 Sheet



Comment: Qty: 0.8442 sf(s)/Unit Total: 3.3768 sf(s)

304/316 .032 Sheet

Batch: 109057

B 9-3-13

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: B

Prog Rev: B

B 9-3-13



2-Deburr if necessary

B 9-3-13

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



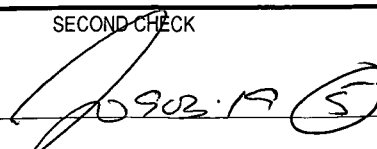
B 9-3-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE


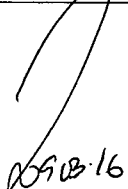


Deburr if necessary

Form D3245-5 as per Dwg D3245 Identify as D3245-5

SB 09/04/16 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-S PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/20  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46174</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/16	#2	Qty +1 part found with all the holes too large holes measure 0.110 supposed to measure 0.078"		scrapped & destroy and replace. Qty 1	FF 09-03-19			
		PL: Se to RF set slightly off on 1st part.						

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:58 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 46174

Part Number: D32455

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/04/16 (45)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

(52)

Identify and Stock  
Location: 79

9/4/16

54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16 74

Job Completion



MF 09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

# **D3245-041 ACCESS PANEL ASSEMBLY**

# **D3245-042 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

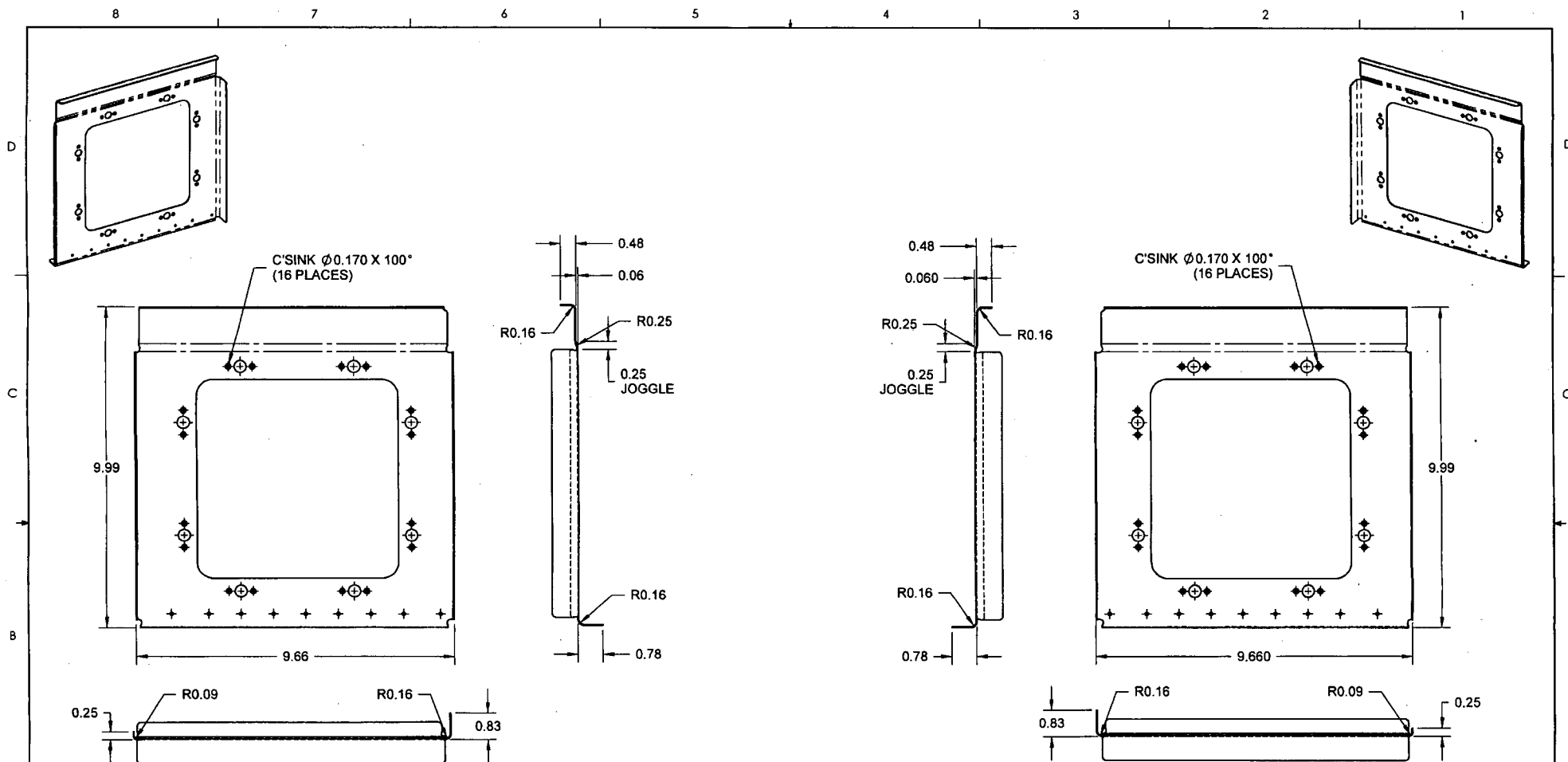
**RELEASED**  
07-10-23

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>	DRAWING NO.	REV. B
CHECKED	<i>PH</i>	D3245	SHEET 1 OF 7
MFG. APPR.	<i>PH</i>	TITLE	SCALE
APPROVED	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2.5
DE APPR.	<i>PH</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

NO  
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ENGINEERING  
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07-10-23



**D3245-1 PANEL BEND DETAIL, LH**

**D3245-2 PANEL BEND DETAIL, RH**

**NOTES:**

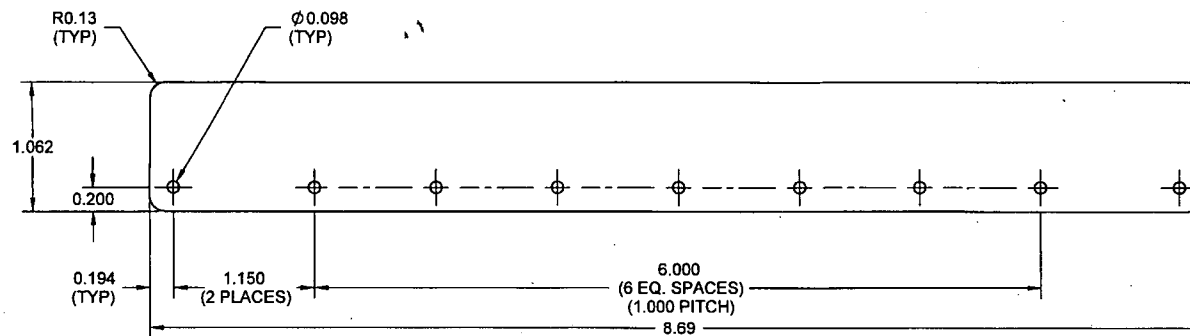
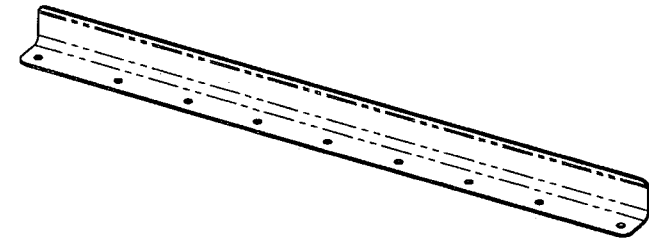
- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

NO. 10-10-23  
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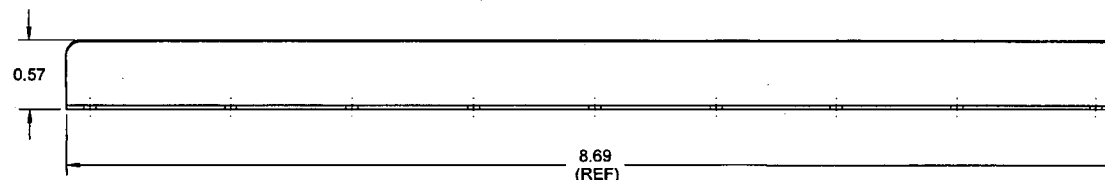
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.		SHEET 2 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		<b>ACCESS PANEL ASSEMBLY</b>	
DATE	<b>07.10.02</b>	1:3	

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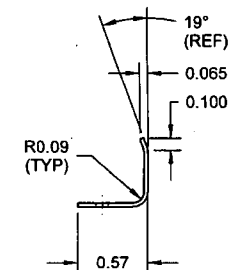
8 7 6 5 4 3 2 1



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**



**RELEASED**  
07.10.23

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3245</b>	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>ACCESS PANEL ASSEMBLY</b>	1:1
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7 6 5 4 3 2 1